

50
DART AEROSPACE LTDW/O split
Work Order:

21918B

Description: Tube Assembly

Part Number:

D3304-044

Dwg: D3304 Rev. A

Qty:

3 10 g X

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PH	04.11.17	10
2	MC	Cut blank: 22.00" as per Dwg D3304 Material: AISI 304/316 SS tubing 0.875" x 0.065" wall (M304TR0.875W.065) Identify for D3304-3 Batch: <u>M15820</u>	PH	04/11/17	11
3	MC	Turn as per Folio FA458 and Dwg D3304 Identify as D3304-3	PH	04/12/01	11
4	QC2	Inspect parts as they come off the CNC machine	PH	04/12/01	11
5	QC8	Second check	PH	04.12.01	11
6	MC	Deburr	PH	04/12/01	11
7	GA	Drill as per Dwg D3304 using drill Jig D3304-T1	2	05-05-11	3
8	GA	Form as per Dwg D3304	2	05-05-11	3
9	GA	Cut tube to length as per Dwg D3304	2	05-05-11	3
10	GA	Deburr	2	05-05-11	3
11	WS	Weld bracket as per Dwg D3304 and QSI 004 <u>using DT875</u> . Pick: Qty Part Number Description Batch 1 D3304-5 Bracket <u>B21920</u>	PH	05-05/17	3
12	QC9	Inspect weld	PH	05-05-18	3
13	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	PH	05 05 18	3
14	QC3	Inspect Powder Coat	SB	05/05/19	3
15	GA	Assemble lanyard and pip pin as per Dwg D3304 Pick: Qty Part Number Description Batch 1 BLBS-0016 Pip Pin <u>M16092</u> 2 CBL-460 Loop Sleeve <u>M16713</u> 12.5" CBL-1240 Cable <u>M16713</u>	SB	05/05/19	3
16	QC5	Inspect work to Step 15	U	05-05-20	3
17	ST	Identify parts with batch number and part number using a fine point permanent marker as per Dwg D3304 and Stock	CZ	05/05/24	3
18	AC	Cost / part: <u>64.81</u>	U	05-05-20	3
19	DC	Close W/O <u>64.81</u> Inspect Level 21	Sec	05.05.25	3
			PH	05.06.01	3

Rev	Date	Change	Revised By	Approved
A	04.09.08	New issue	KJ/JLM	
B	04.09.28	BLBS-0016 changed from BLRS-001	KJ/JLM	
C	04.11.17	Revised Step 15	KJ/JLM	

RELEASED
2017/05/11/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
0501.17	6	Two D3304-3 taken for HAI	18	0501.17	2	18 PRESIDENT	18 0501.17	
0505.11	11	Permanent Clamp, as was Invented.	18	0505.11	N/A	18 PRESIDENT	18 0505.11	

NCR: 21918B		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.12.01	3	3 part are turned taper 1 from $\phi .823 - .835$ 1 from $\phi .820 - .830$ 1 from $\phi .827 - .837$	18 PRESIDENT	acceptable	18	18	18 PRESIDENT	18 PRESIDENT

Part No: D3304-044

PAR #: _____

Fault Category: Production / machine

NCR: Yes No

DQA: 18Date: 05/06/01

NOTE: Date & initial all entries

QA: N/C Closed: 18Date: 05.06.01

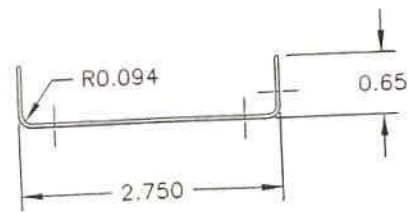
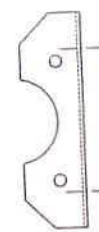
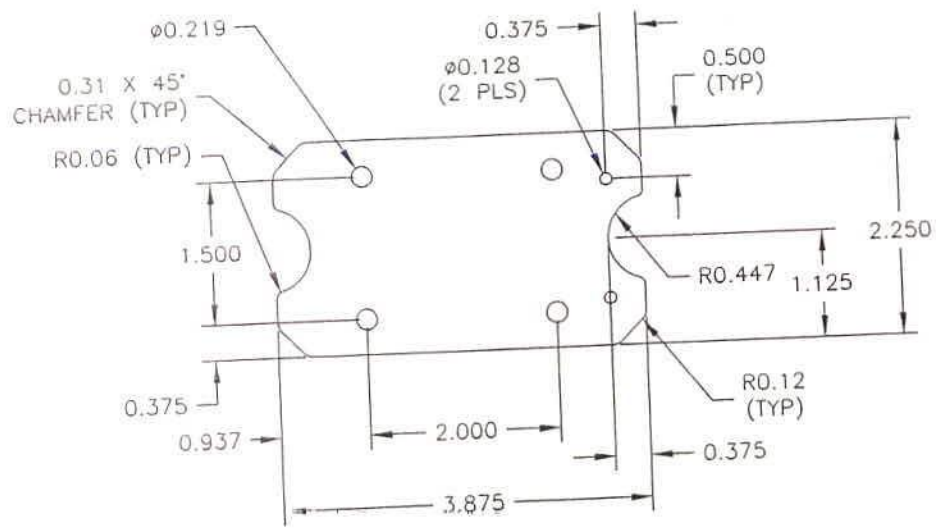
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. A SHEET 4 OF 4
DATE 04.08.18	TITLE TUBE ASSEMBLY		SCALE 1:2

REFERENCE ONLY

RELEASED
04.07.24.18



D3304-5 BRACKET

- NOTES:
- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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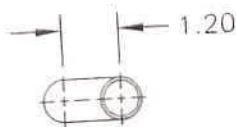
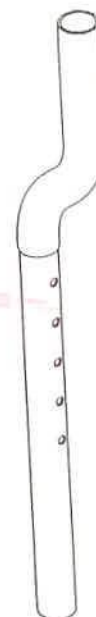
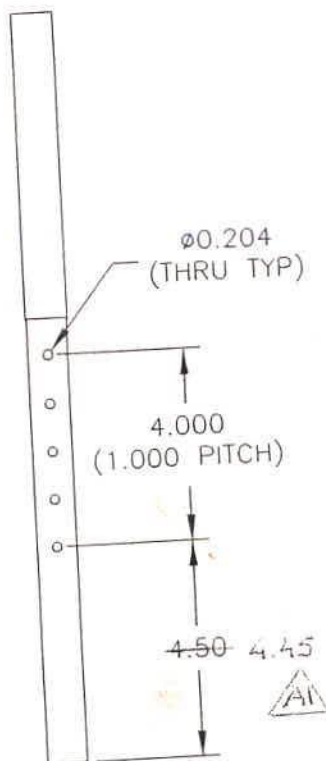
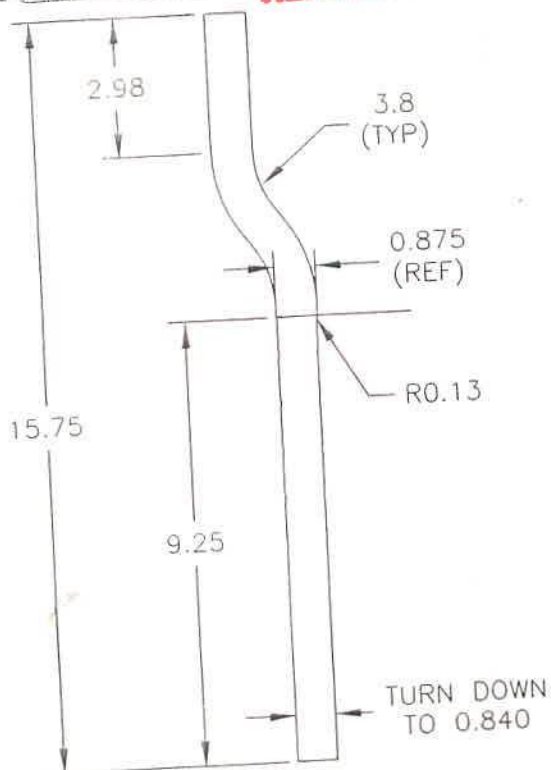
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				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 3 OF 4
				D3304	
DATE	04.08.18	TITLE	TUBE ASSEMBLY	SCALE	1:4

RELEASED
04.09.19 (P)

REFERENCE ONLY



D3304-3 TUBE

D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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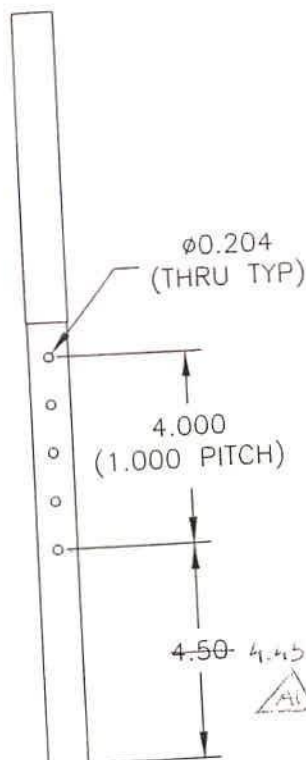
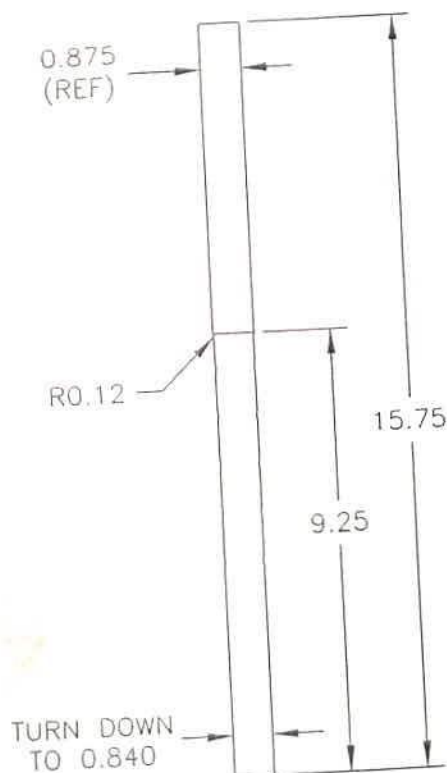
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CHECKED 	APPROVED 	DRAWING NO. D3304	REV. A SHEET 2 OF 4
DATE 04.08.18		TITLE TUBE ASSEMBLY SCALE 1:4	

RELEASED

REFERENCE ONLY

D3304-1 TUBED3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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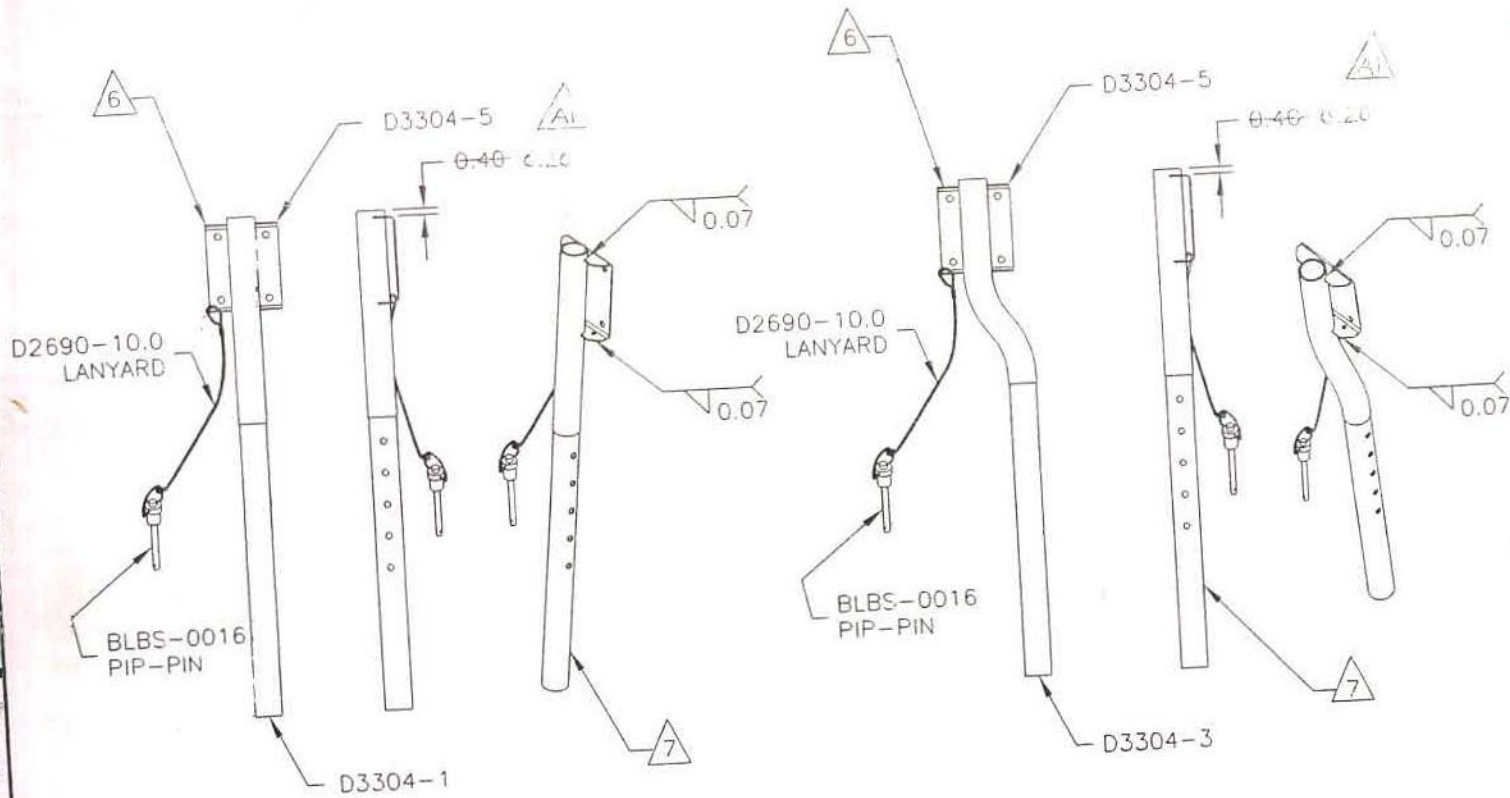
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RF		RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
				D3304	SHEET 1 OF 4
DATE				TITLE	SCALE
04.08.18				TUBE ASSEMBLY	1:6
A				NEW ISSUE	
A1				04.11.23	
				0.20 WAS C.A.C. 7.45 WAS 4.50	

RELEASED
01.07.25



D3304-041 TUBE ASSEMBLY

D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE

D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2004
07:47 am

Work Order No : 0021918 **B**
Project Name : D3304-044
Project For : WK450
Work Order Type : Main
Main WO Number :
House Part Number : D3304-044
Description : Tube Assembly
Manufactured : Yes
Amount Req'd : **109**
Amount Done : **0**
Start Date : 11-16-04
Est Finish Date : 12-04-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00